

The swinging strap *I*, which really is the only thing that makes this jig a closed jig, serves the sole purpose of taking the thrust of the heavy cutting tools when drilling the hole *K* and of steadying the work when facing off the two ends of the hub. The two collar-head screws *K* hold the strap to the jig body and the set-

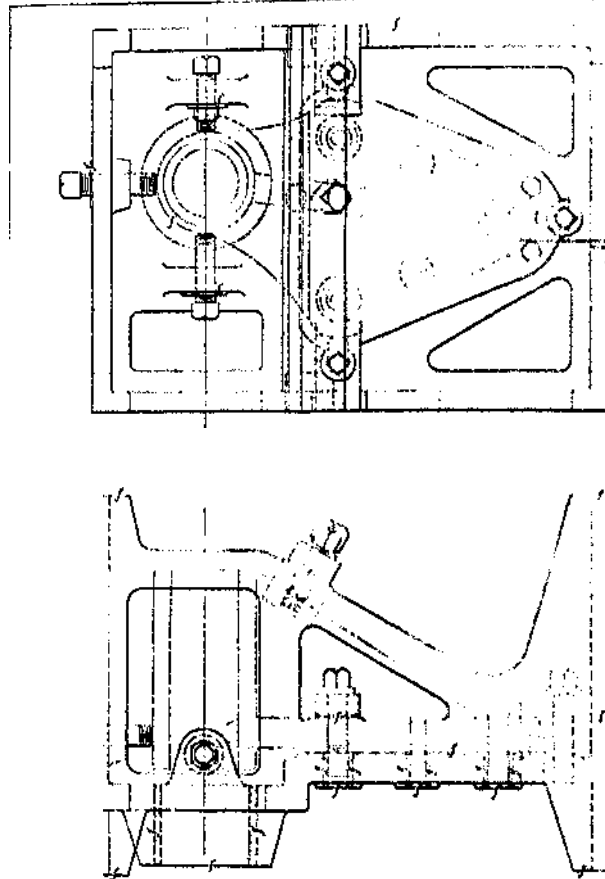


Fig. 16. Plan and Elevation of Jig Stwwa In Fig, *i*\$

screw *L* bears against the work. This strap is easily swung out of the way by loosening one of the collar-head screws, a slot being milled at one end of the strap to permit this. Stationary bushings are used for the screw hole and dowel holes, but for the bearing hole *E* three loose bushings and a lining bushing are employed.